

Interpretation for Qualification of Welders
of Service Line Connections to Mains

Associate Director for Pipeline Safety Regulation, DMT-30

Chief, Eastern Region, DMT-15

In reply to your memo of June 29, 1979:

We understand Mr. Flaherty's question to ask whether or not a person may be qualified under §192.227(a)(2)(i) to weld full encirclement sleeves for service line connections by a nondestructive inspection of the fillet welds used to attach full encirclement sleeves to a pipe. The second part of Mr. Flaherty's question asks whether it is then necessary to use a destructive test, as outlined in Section II, Appendix C, Part 192, if radiography is not allowed.

Section 192.227(a)(2)(i) incorporates by reference the welder qualification standards of section 3 of API Standard 1104. Section 3 allows qualification of a welder by radiography for butt welds only. Since full encirclement sleeves are attached to pipe by filler welds, the answer to the first part of Mr. Flaherty's question is no.

With regard to the second part of Mr. Flaherty's question, in addition to paragraph (a) of §192.227, paragraph (c) provides for welder qualification. Paragraph (c) states: "A welder may qualify to perform welding on pipe to be operated at a pressure that produces a hoop stress of less than 20 percent of SMYS by performing an acceptable test weld, for the process to be used, under the test set forth in Section I of Appendix C to this part. A welder who makes welded service line connection to mains must also perform an acceptable test weld under Section II of Appendix C to this part as a part of his qualifying test...."

The test to qualify a welder of service line connections to pipe operating at less than 20 percent SMYS must be performed as outlined specifically in Section II of Appendix C.

Cesar DeLeon

June 29, 1979

SUBJECT: Interpretation

FROM: Chief, Eastern Region, DMT-15

TO: Associate Director, Office of Pipeline Safety Regulation, DMT-30

THRU: Associate Director, Office of Operations and Enforcement, DMT-10

We have received the following request for interpretation from Mr. John F. Flaherty, Pennsylvania Public Utilities Commission:

Does the use of a fillet weld to install a full encirclement sleeve inspected by radiography in accordance with §192.227(a)(2)(i) meet with the requirements for a service line connection; or is it necessary to use the destructive test as outlined in Paragraph II of Appendix C to certify welders making service line connections?

We would appreciate your interpretation at your earliest convenience.

Lance F. Heverly